

Grey

Dart Aerospace Ltd.

Date: Tuesday, 03/03/2009 4:17:09 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : BRACKET

Job Number : 46283

Estimate Number : 12812

P.O. Number :

Part Number : D3610041

This Issue : 03/03/2009 S.O. No. :

Drawing Number : D3610 REV.A

Prsht Rev. : NC

Project Number : N/A

First Issue : / / Type : MACHINED PARTS

Drawing Revision : A

Previous Run : 40589

Material :

Due Date : 16/03/2009 Qty: 12 Um: Each

Written By :

Checked & Approved By

JUD 09.03.04

Comment : est rev A new issue 07.03.28 EC

est rev B released, changed mat'l EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M4140NB1500X15000

4140 Steel Bar 1.50 x 1.50



Comment: Qty.: 0.5775 f(s)/Unit Total: 6.9300 f(s)

AISI 4140 Steel Bar

M166674

JAF 09/03/06

2.0

BAND SAW

BAND SAW



(12)

Comment: BAND SAW

Cut blank 6.600 " long

mmf 09/03/06

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA692 Rev: AA & Dwg D3610 Rev: A

2-Deburr per dwg D3610

J.F. 09/03/08

(12)

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/03/08

(12)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 09/03/08

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 03/03/2009 4:17:10 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 46283

Part Number: D3610041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-C'SINK AS PER DWG D3610

FF 09-03-10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/03/10

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

14:05

OVEN TEMPERATURE:

320°

FINISH TIME:

14:35

cmp/br

09/03/10

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-10

X12

10.0

MS21075L3

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nutplate

Batch:

109371

FF 09-03-11

11.0

MS20426AD34

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

RIVET

batch:

M104374

FF 09-03-11

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Rivet Nut Plate as per Dwg D3610

FF 09-03-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 03/03/2009 4:17:10 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 46283

Part Number: D3610041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Jo 03-11 (12)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST244A

AS 09/03/11 K12

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/11

Job Completion



MF 09-03-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: H6283
Description: Plate		Part Number: D3610-1
Inspection Dwg: D3610	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

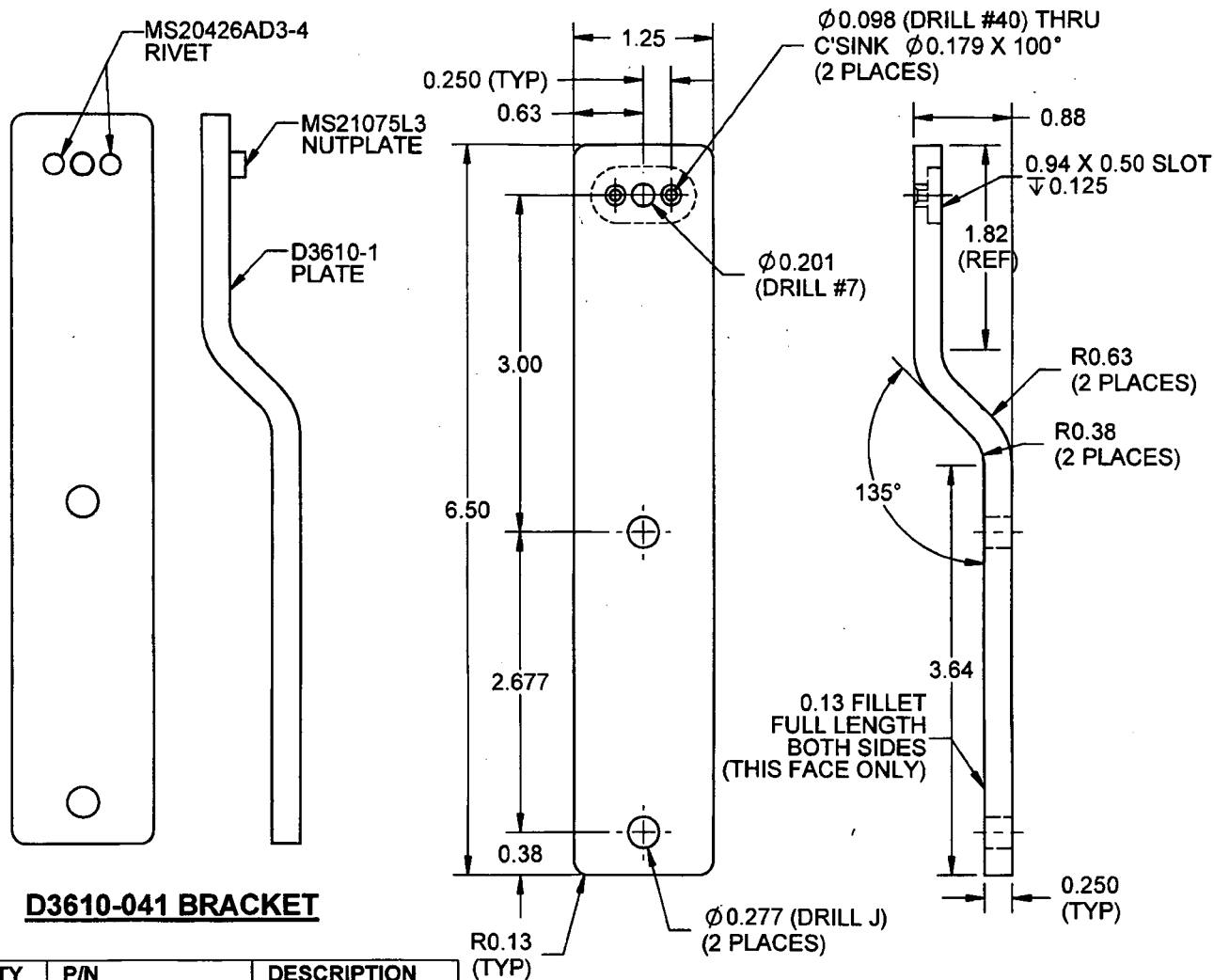
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/-0.030	1.249"	✓			
0.250	+/-0.010	0.251"	✓			
0.63	+/-0.030	0.622"	✓			
6.50	+/-0.030	6.503"	✓			
3.00	+/-0.030	3.002"	✓			
2.677	+/-0.010	2.677"	✓			
0.38	+/-0.030	0.377"	✓			
Ø0.277	+0.006/-0.001	Ø0.278"	✓			
Ø0.201	+0.005/-0.001	Ø0.203"	✓			
Ø0.098	+0.004/-0.001	Ø0.098"	✓			
0.88	+/-0.030	0.871"	✓			
0.94 x 0.50	+/-0.030	0.938 x 0.501"	✓			
0.250	+/-0.010	0.250"	✓			
0.125 depth	+/-0.010	0.134"	✓			

Measured by: J.F.	Audited by: [Signature]	Prototype Approval:	N/A
Date: 09/03/08	Date: 09/03/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.21	New Issue	KJ/DD [Signature]	[Signature]

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3610	REV. A SHEET 1 OF 1
DATE 07.04.20		TITLE BRACKET	SCALE 2:3
REV A	DATE 07.04.20	DESCRIPTION NEW ISSUE	



D3610-041 BRACKET

QTY	P/N	DESCRIPTION
X	BRACKET	D3610-041
1	D3610-1	PLATE
1	MS21075L3	NUTPLATE
2	MS20426AD3-4	RIVET

D3610-1 PLATE

RELEASED

07.04.25

D3610-041 NOTES:

1) IDENTIFY WITH DART P/N "D3610-041" USING FINE POINT PERMANENT INK MARKER

D3610-1 NOTES:

- 1) MATERIAL: 4130N STEEL BAR PER MIL-S-6758 OR AMS 6348 OR 6370 OR 6528 (REF DART SPEC M4130N-B) OR 4140N STEEL BAR PER MIL-S-5626 OR AMS 6382 OR 6349 OR 6529 (REF DART SPEC M4140N-B)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY

RETURN TO

ET MINERINQ

ART SPEC M4130N-B) OF
ART SPEC M4140N-B)
SUBJECT TO AMENDMENT

WITHOUT POLICE

WORK AREA

NO. 14028

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.